

Date: Thursday, 8/30/2007 3:50:27 PM
 User: Kim Johnston

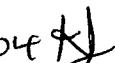
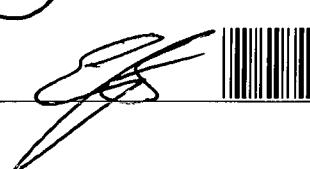
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE KIT	
Job Number	: 34355		Part Number	: K10003	
Estimate Number	: 10532		Drawing Number	: IIN D205-634 REV D	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 8/30/2007 S.O. No. : N/A		Drawing Revision	: D	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 9/30/2007	
Previous Run	: 33461		Qty:	6 Um: Each	
Written By	: <u>JL</u> 107.08.31				
Checked & Approved By					
Comment	: Est : I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF Est : J 06-07-25 As per DSI 9344 JLM Est : K 06.11.17 Per K10003 Rev C KJ Est Rev: L 07.01.12 Document Record for copying bluefile rmv KJ				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL 
Comment: DOCUMENT CONTROL Create White labels only per PPP K10003 CHG 005 07.10.04 		
2.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Pick Packing Kit		
3.0	D2570	Bushing 
Comment: Qty.: 24.0000 Each(s)/Unit Total : 144.0000 Each(s) Bushing Pick: Qty 24 Part Number D2570 Description Bushing Batch <u>333468</u> <u>784</u> - <u>33559</u> <u>664</u> - 		
4.0	D2571	Saddle, Fwd, Out 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Saddle, Fwd, Out Pick: Qty 1 Part Number D2571 Description Saddle Batch <u>B31806</u> - 		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/30/2007 3:50:27 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 34355

Part Number: K10003

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2572 Saddle, Fwd, In



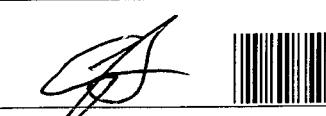
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Saddle, Fwd, In

Pick:

Qty Part Number
1 D2572

Description Batch
Saddle B31648 (44) - B31714 (44) -



B32166 (44) -

6.0 D2573 Saddle, Aft, Out



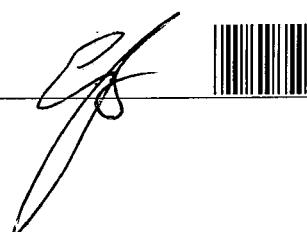
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Saddle, Aft, Out

Pick:

Qty Part Number
1 D2573

Description Batch
Saddle B31721 -



7.0 D2574 Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Saddle, Aft, In

Pick:

Qty Part Number
1 D2574

Description Batch
Saddle B32168 (44) - 2x 34370



8.0 D27361 Lug Assembly



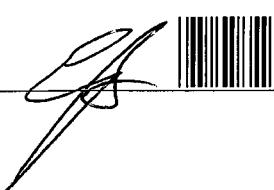
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Lug Assembly

Pick:

Qty Part Number
1 D2736-1

Description Batch
Bracket B32511 -



9.0 D27363 Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Lug Assembly

Pick:

Qty Part Number
1 D2736-3

Description Batch
Bracket B33082 -



8/30/07/01/01/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 34355

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2747

Set Screw



JK



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Set Screw

Pick:

Qty 4

Part Number D2747

Description Socket Head Set Screw

Batch B33470

11.0

D2876

Saddle Spacer



JK



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle Spacer

Pick:

Qty 2

Part Number D2876

Description Spacer

Batch B31227 12 329789 111

12.0

D2877

Saddle Spacer



JK



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle Spacer

Pick:

Qty 2

Part Number D2877

Description Spacer

Batch B32104

13.0

D2968041

Tow Ring



JK



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Tow Ring

Pick:

Qty 1

Part Number D2968-041

Description Tow Ring

Batch B33287

14.0

D35331

Set Screw



JK



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Set Screw

Batch: B28093

15.0

AN46A

Bolt



JK



Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s)

Bolt

Pick:

JK 7/10/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 34355

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty
16

Part Number
AN4-6A

Description
Bolt

Batch

M105057

16.0

AN446A

Bolt

JP



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bolt

Pick:

Qty
4

Part Number
AN4-46A

Description
Bolt

Batch

M104975

17.0

AN451A

Bolt

JP



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Pick:

Qty
8

Part Number
AN4-51A

Description
Bolt

Batch

M103684 (44)

M105281 (44)

18.0

AN612A

Bolt

JP



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Pick:

Qty
8

Part Number
AN6-12A

Description
Bolt

Batch

M105558

19.0

AN960JD416

Washer

JP



Comment: Qty.: 32.0000 Each(s)/Unit Total : 192.0000 Each(s)

Washer

Pick:

Qty
32

Part Number
AN960JD416

Description
Washer

Batch

M104746

20.0

AN960JD616

Washer

JP



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Washer

Pick:

Qty
8

Part Number
AN960JD616

Description
Washer

Batch

M104745

JP 8/30/01 00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/01/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/30/2007 3:50:27 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 34355

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN9704

Washer

HTT



JP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
1	AN970-4	Washer	<u>1104865</u>

22.0

MS21042L4

Nut

HTT



JP



Comment: Qty.: 29.0000 Each(s)/Unit Total : 174.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
29	MS21042L4	Nut (or MS21042-4)	<u>1104683</u>

JP 7/10/07 (6)

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



JP 7/10/07 (6)

Comment: INSPECT KITS 100% FOR COMPLETENESS

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: H

JP 7/10/07 (6)

25.0

QC21

FINAL INSPECTION/W/O RELEASE



(6) 7/10/07

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U \$10.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description	
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)	
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)	
1		X				D205-634-041	SKIDTUBE	
	1		X			D205-634-045	SKIDTUBE	
1	1			X		D205-641-011	GROUND HANDLING KIT	
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)	
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)	
2A			16	16		D2594-1	* PLUG	
2B			16	16		D2594-3	* O-RING	
3			1	1		D2855	* AFT CAP	
4			2	2		AN3-5A	* BOLT	
5			2	2		AN960JD10L	* WASHER	
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)	
6B			1	1		D3566-1	* GASKET	
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)	
7B			1	1		D3566-1	* GASKET	
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)	
8B			1	1		D3566-5	* GASKET	
9A			1	1		D3564-13	* WEARSHOE	
9B			1	1		D3566-13	* GASKET	
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)	
11			50	50		AN960C10L	* WASHER (REPLACES AN960JD10L)	
12			50	50		ALS4-1032-130	* INSERT	
13			2	2		ALS4-1032-225	* INSERT	
20	1	1				D2571	SADDLE, FWD OUTSIDE	
21	1	1				D2572	SADDLE, FWD INSIDE	
22	1	1				D2573	SADDLE, AFT OUTSIDE	
23	1	1				D2574	SADDLE, AFT INSIDE	
24	8	8				AN4-51A	BOLT	
25	16	16				D2570	BUSHINGS	
26	8	8				MS21042L4	NUT (OR MS21042-4)	
27	8	8				AN6-12A	BOLT	
28	8	8				AN960JD616	WASHER	
29	16	16				AN4-6A	BOLT	
30	32	32				AN960JD416	WASHER	
31	16	16				MS21042L4	NUT (OR MS21042-4)	
32	4	4				D2747	SET SCREW	
33	2	2				D3533-1	SET SCREW	
40	1	1				D2968-041	TOW RING	
41	1	1				AN970-4	WASHER	
43	1	1				MS21042L4	NUT (OR MS21042-4)	
50				1	D2736-1	GHW LUG		SHOP COPY
51				1	D2736-3	GHW LUG		RETURN TO
52				4	AN4-46A	BOLT		ENGINEERING
53				8	D2570	BUSHING		UNCONTROLLED COPY
54				4	MS21042L4	NUT (OR MS21042-4)		SUBJECT TO AMENDMENT
60	2	2			D2876	SADDLE SPACER		WITHOLD NOTICE
61	2	2			D2877	SADDLE SPACER		WORK ORDER

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

NO. 24355

• COPYRIGHT © 1996 BY DART AEROSPACE LTD •
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: D
Date: 07.04.10